

Date: Friday, 03/10/2008 2:54:19 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 42435
Estimate Number : 13598
P.O. Number :
This Issue : 03/10/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SMALL /MED FAB
Previous Run :
Written By :
Checked & Approved By :
Comment : Est Rev:A 08-09-18 new issue DD verified by:EC

Drawing Name : PACKER
Part Number : D38155
Drawing Number : D3815 PRELIM
Project Number : N/A
Drawing Revision : PRELIM
Material :
Due Date : 06/10/2008 **Qty:** 8 **Um:** Each

FOR ENGINEERING USE ONLY

proto

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M2024T3S125 2024-T3 .125 sheet



Comment: Qty.: 0.1869 sf(s)/Unit Total : 1.4952 sf(s)
2024-T3 .125" sheet
batch: 102027 IB 8-10-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3815
Dwg Rev: PRE
Prog Rev: PRE

IB 8-10-2

⑨

2-Deburr if necessary

IB 8-10-2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-10-2

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08-10-06

⑧

PTD LAST PAGE

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FL 08/10/06

⑧

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Drawing Name: PACKER

Job Number: 42435

Part Number: D38155

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

Howley

JS

08/10/06

(x8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



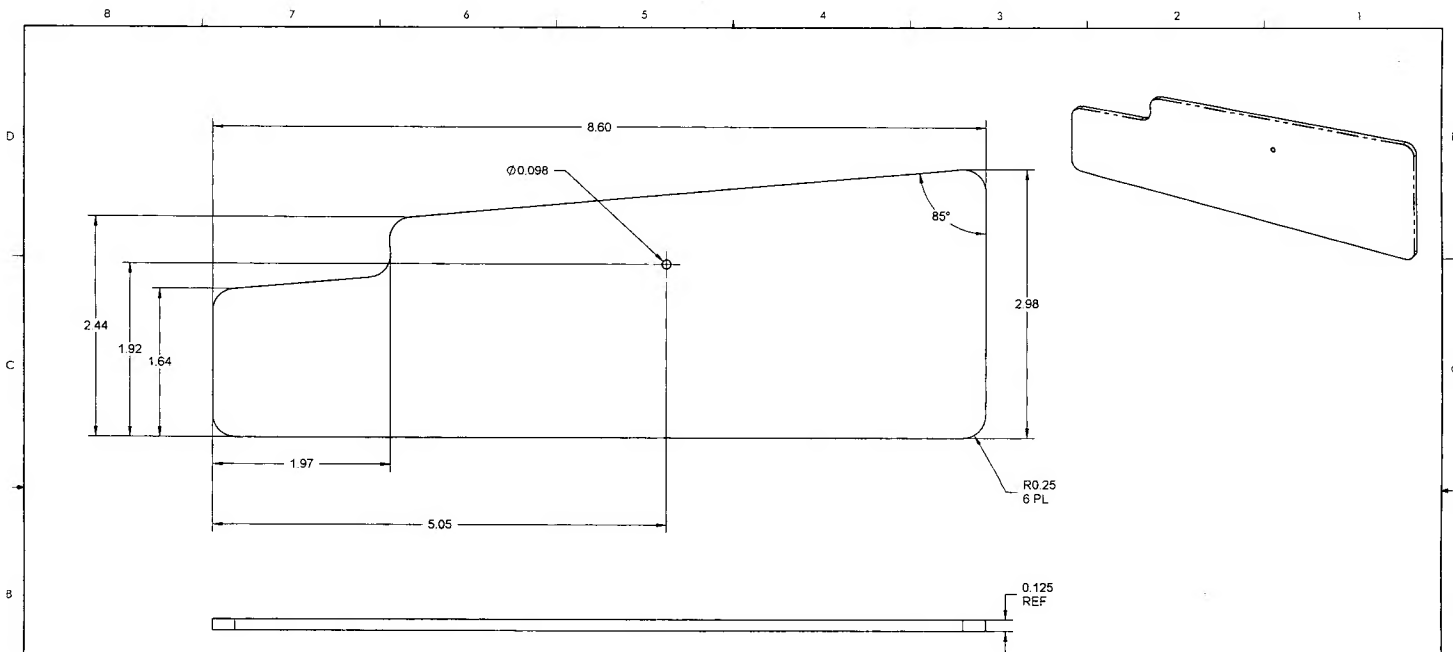
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



00252A

U 08-10-06



D3815-5 PACKER

NOTES:

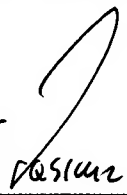
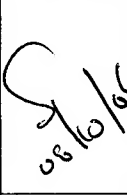
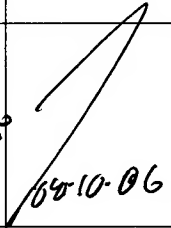
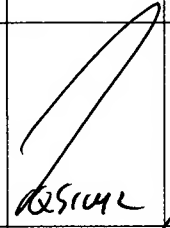

- 1) MATERIAL: 2024-T3 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-3 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3815	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	08.09.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-06	4.0	Upon inspection 1 part was found to have a blow out line going across the part, 2" long: .020~.005" deep. R.e: Machine Malfunction.		Scrap: no replace.	 08/10/06	 08-10-06	 08-10-06	 08-10-06

NOTE: Date & initial all entries